

Work Order ID 59081

May 26, 2010 9:05:10 AM



Page 1

Item ID:	D4030-041	Accept		Setup	Start	
Revision ID:					Stop	
Item Name:	Long Basket Assembly (350)					
Start Date:	5/26/10	Start Qty:	1.00		Cust Item ID:	
Required Date:	6/03/10	Req'd Qty:	1.00		Customer:	
Reference:						

Approvals:	Process Plan:		Date:	Tooling:	Date:	Run	Start	
	QC:		Date:	SPC (Y/N):	Date:		Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D4030	B								
100	Pick Kit	0.00							
	Packaging	Memo							
	Packaging								
110	Assemble as per dwg	0.00							
	HandFinish	Memo							
	Hand Finishing								
120	QC5- Inspect part completeness to step on W/O	0.00							
	QC	Memo							
	Quality Control								

6/14/10 2

5/30/06/04

5/10/06/04

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 59081

May 26, 2010 9:05:10 AM



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Item ID: D4030-041

Accept



Setup Start



Revision ID:

Stop



Item Name: Long Basket Assembly (350)

Start Date: 5/26/10 Start Qty: 1.00



Cust Item ID:

Required Date: 6/03/10 Req'd Qty: 1.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130

Identify as per dwg & Stock Location: _____

0.00



Packaging

w/o 59078

Memo

0.00

Packaging

D350-607-441

10/16/04

140

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10/06/04

MF
10-6-4

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

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Work Order ID: 59081

Parent Item: D4030-041

Parent Item Name: Long Basket Assembly (350)

Start Date: 5/26/10






Required Date: 6/03/10

Comments: IPP Rev:A new issue DD 10.03.23 verified by:EC
per dwg revB DD 10.04.20 verified by:EC

IPP Rev:B as

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2530  Handle Weldment		Manufactured	No			100	Each	6.0000	1	1			
				<u>Location</u>			<u>Loc Qty</u>	<u>Loc Code</u>					
				ST506			6						
				58428			6			58428			
D2535  Spring		Manufactured	No			100	Each	136.0000	2	2			
				<u>Location</u>			<u>Loc Qty</u>	<u>Loc Code</u>					
				ST504			136						
				56355			36			56355			
				58331			100						
D2537  Bushing		Manufactured	No			100	Each	45.0000	4	4			
				<u>Location</u>			<u>Loc Qty</u>	<u>Loc Code</u>					
				ST504			45						
				57722			5			57722 14			
				58429			40			58429 34			
D3913-041  Long Basket Base Assembly, 350		Manufactured	No			100	Each	0.0000	1	1			
								B59083 (1X)				5/10/06/04	
D3914-041  Long Basket Lid Assembly (350)		Manufactured	No			100	Each	0.0000	1	1			
								B59084 (1X)				5/10/06/04	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

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Page 2

Work Order ID: 59081

Parent Item: D4030-041

Parent Item Name: Long Basket Assembly (350)

Comments: IPP Rev:A new issue DD 10.03.23 verified by:EC
per dwg revB DD 10.04.20 verified by:EC



IPP Rev:B as

Start Date: 5/26/10

Required Date: 6/03/10



Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D3917-3  Washer		Manufactured	No			100	Each	1.0000	6	6 ✓ 58892			



Location Loc Qty Loc Code

ST096 1
57144 1

D3953-3  Gas Spring Stud, Lid		Manufactured	No			100	Each	1.0000	2	2 ✓ 58894 1x			
--	--	--------------	----	--	--	-----	------	--------	---	-----------------	--	--	---


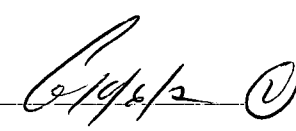
Location Loc Qty Loc Code

ST139B 1
58858 1

D3953-7  Spring Spacer		Manufactured	No			100	Each	1.0000	2	2 ✓ 58893 1x			
---	--	--------------	----	--	--	-----	------	--------	---	-----------------	--	--	---

Location Loc Qty Loc Code

ST101 1
53970 1

D3953-9  Gas Spring Washer		Manufactured	No			100	Each	13.0000	2	2 ✓ 53970 1x			
---	--	--------------	----	--	--	-----	------	---------	---	-----------------	--	--	---

Location Loc Qty Loc Code

ST101 13
53642 13

53642

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Work Order ID: 59081



Parent Item: D4030-041



Parent Item Name: Long Basket Assembly (350)

Start Date: 5/26/10

Required Date: 6/03/10

Comments: IPP Rev:A new issue DD 10.03.23 verified by:EC
per dwg revB DD 10.04.20 verified by:EC

IPP Rev:B as

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D3953-17 Gas Spring Spacer		Manufactured	No			100	Each	13.0000	2	2			

Location Loc Qty Loc Code

ST101 13
57143 1
58857 12

D3953-19 Gas Spring Bracket		Manufactured	No			100	Each	6.0000	1	58857 1			
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Location Loc Qty Loc Code

ST101 6
57607 6

D3953-21 Gas Spring Bracket		Manufactured	No			100	Each	14.0000	1	57607 1			
------------------------------------	--	--------------	----	--	--	-----	------	---------	---	------------	--	--	--

Location Loc Qty Loc Code

ENG 5
56407 5
ST102 9
57145 9

D3969-3 Spring (Basket Lid)		Manufactured	No			100	Each	0.0000	1	57145 56386			
------------------------------------	--	--------------	----	--	--	-----	------	--------	---	----------------	--	--	--

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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Work Order ID: 59081

Parent Item: D4030-041

Parent Item Name: Long Basket Assembly (350)

Comments: IPP Rev:A new issue DD 10.03.23 verified by:EC
per dwg revB DD 10.04.20 verified by:EC





IPP Rev:B as

Start Date: 5/26/10

Required Date: 6/03/10

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
AN3-14A  Bolt		Purchased	No			100	Each	66.0000	4	4			
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST351		66							
					114330	66				114330			
AN3-16A  Bolt		Purchased	No			100	Each	159.0000	2	2			
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST352		159							
					113845	39				113845			
					114523	20							
					114752	100							
AN5-17A  Bolt		Purchased	No			100	Each	139.0000	4	4			
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST323		34							
					114324	34				114324			
				ST339		105							
					113538	5							
					114330	100							
AN4-12  Bolt		Purchased	No			100	Each	26.0000	3	3			
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST357		26							
					114292	26				114292			

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Work Order ID: 59081



Parent Item: D4030-041



Parent Item Name: Long Basket Assembly (350)

Start Date: 5/26/10

Required Date: 6/03/10

Comments: IPP Rev:A new issue DD 10.03.23 verified by:EC
per dwg revB DD 10.04.20 verified by:EC

IPP Rev:B as

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
AN310-4 		Purchased	No			100	Each	81.0000	3	3			
NUT													

Location Loc Qty Loc Code

ST139 21
114341 21
ST324 47
114716 47
ST349 13
114341 13

AN310C4 		Purchased	No			100	Each	64.0000	2	2			
Nut													

Location Loc Qty Loc Code

ST349 64
114306 64

MS21042L3 		Purchased	No			100	Each	1,722.000	6	6			
Nut													

Location Loc Qty Loc Code

ST300 1722
113537 20
113644 202
114523 1000
114718 500

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

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Work Order ID: 59081

Parent Item: D4030-041

Parent Item Name: Long Basket Assembly (350)

Start Date: 5/26/10

Required Date: 6/03/10

Comments: IPP Rev:A new issue DD 10.03.23 verified by:EC
per dwg revB DD 10.04.20 verified by:EC

IPP Rev:B as

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
MS21042L5		Purchased	No			100	Each	516.0000	4	4			
Nut													

Location	Loc Qty	Loc Code
ST300	516	
113523	13	
113537	3	
114437	100	
114449	400	

MS24665-151		Purchased	No			100	Each	668.0000	3	3			
Cotter Pin													

Location	Loc Qty	Loc Code
ST309	668	
17566	668	

MS24665-300		Purchased	No			100	Each	74.0000	2	2			
Cotter Pin													

Location	Loc Qty	Loc Code
ST309	74	
105279	2	
110123	72	

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Page 6

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

May 26, 2010 9:05:01 AM

Work Order ID: 59081



Parent Item: D4030-041



Parent Item Name: Long Basket Assembly (350)

Start Date: 5/26/10

Required Date: 6/03/10

Comments: IPP Rev:A new issue DD 10.03.23 verified by:EC
per dwg revB DD 10.04.20 verified by:EC

IPP Rev:B as

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
NAS1149F0432P		Purchased	No			100	Each	775.0000	6	6			



Washer

Location	Loc Qty	Loc Code
ST275	775	
112940	92	
114405	1	
114576	182	
114718	500	

M114576

[Handwritten signature]

NAS1149F0563P Purchased

No

100

Each

240.0000

4

4



Washer

Location	Loc Qty	Loc Code
ST275	40	
108471	40	
ST298	200	
114576	200	

108471

[Handwritten signature]

NAS1149F0332P Purchased

No

100

Each

811.0000

8

8



WASHER

Location	Loc Qty	Loc Code
ST275	811	
18057	811	

18057

[Handwritten signature]

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

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May 26, 2010 9:05:02 AM

Work Order ID: 59081



Parent Item: D4030-041



Parent Item Name: Long Basket Assembly (350)

Start Date: 5/26/10

Required Date: 6/03/10

Comments: IPP Rev:A new issue DD 10.03.23 verified by:EC
per dwg revB DD 10.04.20 verified by:EC

IPP Rev:B as

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
NAS1149C0432R		Purchased	No			100	Each	770.0000	2	2			



Washer



[Signature]

Location

Loc Qty

Loc Code

ST297

770

114292

170

114742

600

114292

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

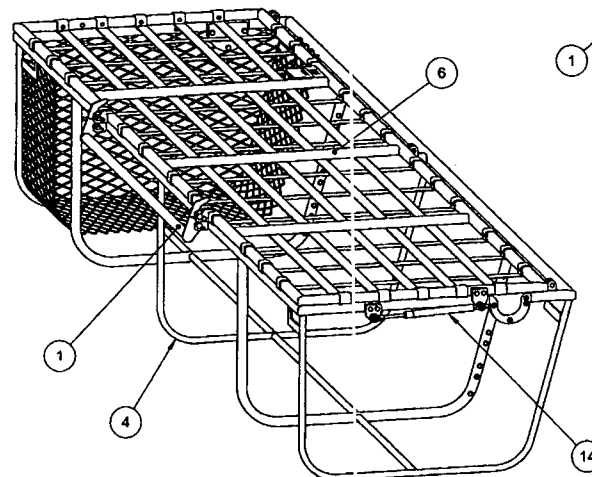
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

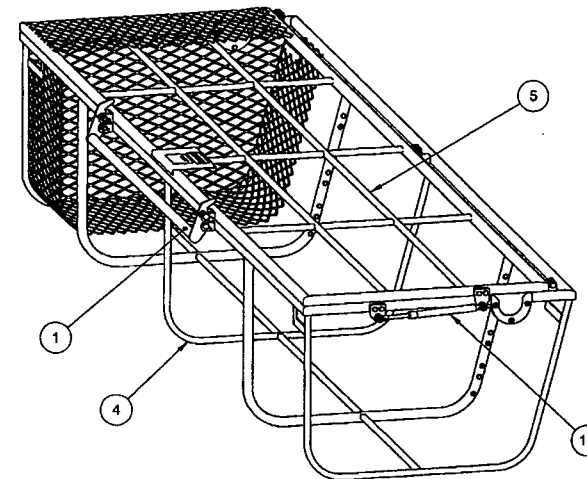
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

ITEM	QTY -041	QTY -043	P/N	DESCRIPTION
	X		D4030-041	LONG BASKET ASSY (350)
		X	D4030-043	LONG BASKET ASSY, LIGHT LID (350)
1	1	1	D2530	HANDLE WELDMENT
2	2	2	D2535	SPRING
3	4	4	D2537	BUSHING
4	1	1	D3913-041	LONG BASKET BASE ASSY (350)
5	1		D3914-041	LONG BASKET LID ASSY (350)
6		1	D3915-041	LIGHT LID ASSY-LONG BASKET
7	6	6	D3917-3	WASHER
8	2	2	D3953-3	GAS SPRING STUD, LID
9	2	2	D3953-7	GAS SPRING SPACER
10	2	2	D3953-8	GAS SPRING WASHER
11	2	2	D3953-17	GAS SPRING SPACER
12	1	1	D3953-19	GAS SPRING BRACKET
13	1	1	D3953-21	GAS SPRING BRACKET
14	1	1	D3969-3	SPRING
15	4	4	AN3-14A	BOLT
16	2		AN3-16A	BOLT
17		2	AN3-20A	BOLT
18	3	3	AN4-12	BOLT (DRILLED)
19	4	2	AN5-17A	BOLT
20		2	AN5-21A	BOLT
21	3	3	AN310-4	NUT, CASTELLATED
22	2	2	AN310C4	NUT, CASTELLATED
23	6	6	MS21042L3	NUT
24	4	4	MS21042L5	NUT
25	3	3	MS24665-151	COTTER PIN
26	2	2	MS24665-300	COTTER PIN
27	6	6	NAS1149F0432P	WASHER
28	4	4	NAS1149F0563P	WASHER
30	8		NAS1149F0332P	WASHER
31	2		NAS1149C0432R	WASHER



D4030-043 LONG BASKET ASSY, LIGHT LID (350)
(MESH SHOWN LOCALLY FOR CLARITY)



D4030-041 LONG BASKET ASSY (350)
(MESH SHOWN LOCALLY FOR CLARITY)

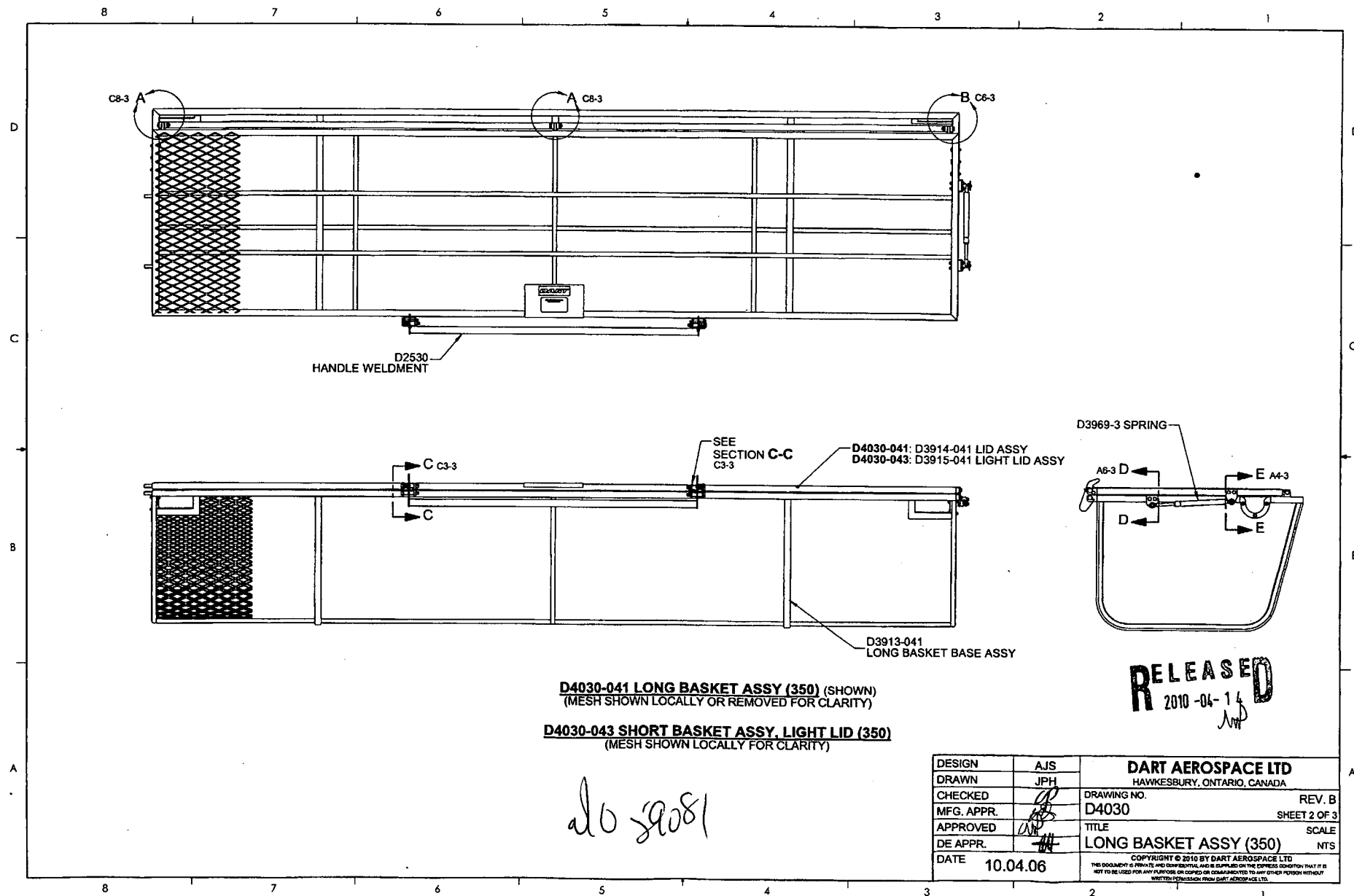
NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: -041: 72 lbs APPROX
-043: 57 lbs APPROX

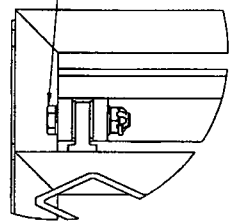
WLO 59081

RELEASED
2010-04-14

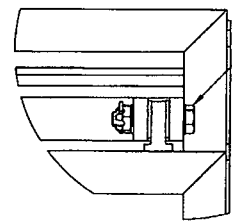
B	AN5-21A BOLT WAS AN5-19A: BOM & (D3-3)	JPH	10.04.06
A	NEW ISSUE	JPH	10.03.16
REV.	DESCRIPTION	BY	DATE
DESIGN	AJS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	JPH	DRAWING NO.	REV. B
CHECKED	GP	D4030	SHEET 1 OF 3
MFG. APPR.	KPS	TITLE	SCALE
APPROVED	AMP	LONG BASKET ASSY (350)	NTS
DE APPR.	MP	COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSES OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	
DATE	10.04.06		



AN4-12 BOLT
D3917-3 WASHER, 2X
NAS1149F0432P WASHER, 2X
AN310-4 NUT, CASTELLATED
MS24665-151 COTTER PIN

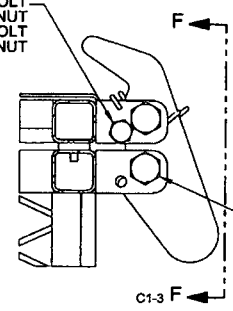


DETAIL A D8-2
D5-2



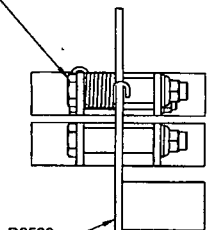
DETAIL B D3-2

D4030-041: AN3-16A BOLT
MS21042L3 NUT
D4030-043: AN3-20A BOLT
MS21042L3 NUT

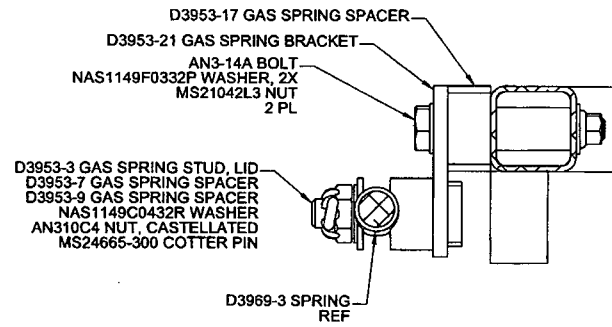


SECTION C-C B4-2
B6-2

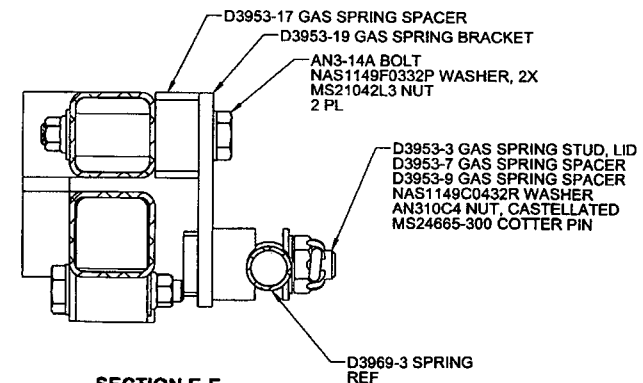
D4030-041: AN5-17A BOLT
D2537 BUSHING
D2535 SPRING
NAS1149F0563P WASHER
MS21042L5 NUT
D4030-043: AN5-21A BOLT
D2537 BUSHING
D2535 SPRING
NAS1149F0563P WASHER
MS21042L5 NUT



VIEW F-F C3-3



SECTION D-D B2-2



SECTION E-E B1-2

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2010-04-14
MP

WLO 59081

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DE APPR.	JP	LONG BASKET ASSY (350)	NTS
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